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# **Information for Applicants for POULTRY INSPECTION**

AMS-219

UNITED STATES DEPARTMENT OF AGRICULTURE  
Agricultural Marketing Service  
Washington, D. C.

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SECTION I.   OUTLINE OF PRELIMINARY STEPS FOR APPLICANTS.

A.   Poultry Products Inspection Act.

The Poultry Products Inspection Act (P.L. 85-172) became law on August 30, 1957. Its purpose as stated in the Act is " . . . to prevent the movement in interstate or foreign commerce or in a designated major consuming area of poultry products which are unwholesome, adulterated, or otherwise unfit for human food."

B.   Plants Required to Receive Inspection.

Effective January 1, 1959, any establishment slaughtering poultry for transportation or sale in interstate commerce is required under the law to receive inspection. Also required to have inspection is any establishment slaughtering poultry for transportation between official establishments even though both plants are in the same State; for example: When New York dressed poultry is slaughtered in one plant and moves to an official eviscerating plant - both plants would be required to have inspection service. As has been required for several years, plants which sell dressed poultry or poultry products to official establishments, that voluntarily receive inspection under the Act in 1958,, must have their poultry processed under inspection.

C.   Deadline for Inspection.

Inspection will be required by January 1, 1959, unless a plant is specifically exempted. However, applicants may apply now and inspection may be furnished after May 1, 1958.

D.   Where Application Forms can be Obtained.

Application forms may be obtained at any one of the following offices:

1. Facilities Section, Inspection Branch, Poultry Division, Agricultural Marketing Service, USDA, Washington 25, D. C.
2. Dr. J. R. Harney, 200 Customs Building, 2nd and Chestnut Streets, Philadelphia 6, Pennsylvania.

States Supervised:

Connecticut, Delaware, Maine, Maryland, Massachusetts, New Hampshire, New Jersey, New York, Pennsylvania, Rhode Island, Vermont, Virginia, West Virginia, Washington, D. C.

3. Dr. W. S. Buchanan, 1014 U. S. Customs House, 610 S. Canal Street, Chicago 7, Illinois.

States Supervised:

Illinois, Indiana, Kentucky, Michigan, Missouri, Ohio, Wisconsin.

4. Dr. H. E. Gaskill, 333 Pacific Building, 821 Market Street, San Francisco 3, California.

States Supervised:

Arizona, California, Idaho, Montana, Nevada, Oregon, Utah, Washington, Wyoming.

5. Dr. R. B. Mericle, 504 Iowa Building, Des Moines 9, Iowa.

States Supervised:

Colorado, Iowa, Kansas, Minnesota, Nebraska, North Dakota, South Dakota.

6. Dr. Jonathan Keim, 900 Peachtree Building, 900 Peachtree Street, N. E., Atlanta 23, Georgia.

States Supervised:

Alabama, Florida, Georgia, Mississippi, North Carolina, South Carolina, Tennessee.

7. Dr. Kenneth McEnroe, 558 Terminal Annex Building, Dallas 2, Texas.

States Supervised:

Arkansas, Louisiana, New Mexico, Oklahoma, Texas.

E. How to Make Application.

Make application for inspection by completing the form, "Application for Inspection," in three copies, and mailing all three to: Facilities Section, Inspection Branch, Poultry Division, AMS, USDA, Washington 25, D. C. (See example Exhibit 1.)

F. Qualifying a Plant to Receive Inspection.

1. To qualify a plant to receive inspection, prepare four sets of blueprints and forward them to: Facilities Section, Inspection Branch, Poultry Division, AMS, USDA, Washington 25, D. C.

- a. See attached copy of regulations and section II herein. Blueprints shall consist of floor plans, building elevations, and a plot plan.

- b. Blueprints will be either approved or returned for changes and amendment. If approved, one approved copy will be returned to the applicant, and three copies will be retained by the Government. (The regulations state that technical assistance may be provided in bringing plants into compliance, where requested.)

2. See that the plant conforms to the approved blueprints.

3. Notify the Facilities Section when plant is in compliance with blueprints.
4. Facilities Section will arrange for a final survey.

If at the time of final survey, it is determined that the plant is in compliance, the plant is eligible to receive inspection. Subsequently, a letter of plant approval will be forwarded to the establishment. When, or immediately before service is installed, an official plant number will be assigned to the establishment.

G. Labels.

The labels used on poultry must be approved by the Inspection Branch, Poultry Division, AMS, Washington 25, D. C. in advance of the time service is to be inaugurated in an establishment. It is recommended that applicants become thoroughly familiar with the requirements of Sections 81.125 through 81.146 of the regulations before definite plans for labels are completed.

SECTION II. BUILDING CONSTRUCTION AND FACILITIES.

When planning a new poultry processing plant or remodeling a plant to meet the minimum standards as set forth in the regulations, you should become fully familiar with Sections 81.31 through 81.43 of the regulations. The following information is presented in order to clarify items which have given some applicants difficulty in interpretation:

A. Plant Building.

The outside construction of the building has no particular bearing on the eligibility of an applicant to receive inspection, except that the building shall be of sound construction and in good repair.

B. Live Poultry Receiving Area.

The unloading dock for receiving poultry should be concrete in order that it may be kept clean and properly washed down. A floor drain should be provided in this area.

C. Live Poultry and Inedible Areas.

The truck areas where live poultry is received and refuse removed from the plant should be constructed of concrete and provided with a drain in order that sanitation may be maintained.

D. Inedible Room.

Inedible Room should be equipped with power exhaust fans to be properly ventilated. The room should be big enough to store all empty refuse containers as well as the full containers. The walls, floors, and ceilings shall be of hard, smooth material impervious to moisture. Hot and cold water outlets and hose should be provided in this room.



It should be in a location convenient to the processing room but should be entirely separate and have tight fitting doors. Adequate floor drainage shall be provided.

E. Poultry Dressing Room:

The poultry dressing room shall be separated from the eviscerating room by a wall which extends to the ceiling. Openings are permitted in the separating wall for bringing poultry into the room and for the return of the conveyor to the poultry dressing room. Doors between the rooms shall be equipped with a self-closing device. Floors should be properly drained by either trench or deep sealed trapped drains. Keep in mind the formula of one drain for every twenty foot bay which gives ten feet from the high point to the drain. The floor drains should be located so that the flow of all waste water is direct to drains. The walls should be smooth-finished cement plaster or other impervious material, such as tile, from floor to ceiling. Some types of plastic and other paints which are impervious to moisture when properly applied to walls are satisfactory. In waterproofing walls with some of the suitable plastics, it is recommended that the juncture of the wall and floor and the lower four or five feet of the wall be reinforced with fiberglass to give added durability. This will help prevent breaks in the wall covering which might result when chill vats or trucks bump into the walls. Sufficient hot and cold water clean-up outlets, with racks for hose, shall be supplied. For proper equipment arrangement, the boiler room should be located near the scald tank. Adequate ventilation (exhaust fan) should be provided in the scald tank area.

F. Bleeding Alley.

It is recommended that a water flushed bleeding alley be used to provide an acceptable sanitary operation. It should be constructed of tile or trowel-finished Portland cement. Some of the plastic-coated walls have also proven satisfactory. The bleeding alley should have the floors adequately sloped to a drain. Trench drains are dangerous in this floor if the arch is not water-flushed, due to the slippery coagulated blood. If necessary, blood may accumulate in this area. The width and length of the alley will depend on the size of birds to be processed and rate of production. The poultry should be completely bled before it reaches the scald tank.

G. Poultry Eviscerating Room.

The floors should be of concrete, float-finished, properly pitched to drains, and placed so that the waste water will not drain over the floor area. Other equally impervious and smooth floor construction materials are satisfactory. If closed drains are used they shall be vented to the outside. (Again keep in mind the formula of one drain in the center of each twenty foot bay). The side walls shall be smooth-finished and impervious to moisture to a height of at least six feet above the floor. We recommend cement plastered, tiled, or plastic-coated wall construction. The remainder of the walls to the ceiling shall be smooth and resistant to moisture.



#### H. Length of Eviscerating Line.

In calculating the length of eviscerating line required keep in mind the Graphic Standards recommended under Dimensions of Human Figure - that 38 inches of linear line space are needed for an employee at work with elbows out sideward. Therefore, we recommend that 34 inches to 38 inches be allowed for each employee working on the line. The work space an employee needs when standing and working on a job before him is 2 feet 10 inches (from back to tip of fingers). When sitting 2 feet 2 inches are required (back to tip of fingers). Keep in mind that for efficient operation, the product should move in an even flow toward the packing and shipping area. Product should move from poultry dressing room, to eviscerating room, to chill tank room, to packing room, to refrigerating room.

#### I. Cooling and Packing Area.

The floors in the cooling area where tanks are drained shall have ample drainage. The side walls should be cement, plastered or tiled for a minimum of six feet. Plastic coated walls are also satisfactory. The remainder of wall to the ceiling shall be smooth and resistant to moisture.

#### J. Floors, Walls and Ceilings.

To promote good sanitation, the floors, walls, and ceilings in the various workrooms should be constructed of material that can be readily kept clean. Wood structures and equipment are absorbent and difficult to keep clean. Therefore the use of wood is limited to areas with high ceilings and in areas where moisture is at a minimum. Properly applied plastic covering of wooden surfaces is satisfactory. The use of plywood, which is available in large sheets, is preferable to dressed and matched lumber, as there are fewer joints that offer a harbor for roaches or other vermin.

Floors requiring drainage shall be constructed of impervious material, such as dense concrete or vitrified floor brick of good quality laid on a concrete base.

The accident rate is high in poultry plants. This is why we caution you that on all equipment, waste water should flow direct to drain, not over large areas of the floor. Drainage pipes or loose equipment should not extend over the floor. Safety guards should be installed on all mechanical equipment.

Interior walls should be smooth and flat so far as structural considerations permit, and ceiling surfaces should be smooth and flat. Wall surfaces in workrooms should be constructed of glazed brick, glazed tile, smooth Portland cement plaster, acceptable plastics, or other nonabsorbent material.

Sufficient hot and cold water connections with short hoses and racks

for clean-up purposes shall be provided. Ceilings should be of a height of at least 10 feet.

To avoid damage to window glass from impact or hand trucks, the window sills should be 3 feet or more above the floor. Window sills should be sloped about 45 degrees to promote sanitation.

K. Floor Drainage.

All floors where wet operations are conducted should be well drained. A slope of 1/8 inch to 1/4 inch per foot to drainage inlets is desirable for usual conditions. Floor drains should be so located that high points of the floor are not over 10 feet from a drain. In packaging areas high points of the floor should not be over 15 feet from a drain. To avoid accidents, excessively smooth floors should be avoided. Good results have been obtained by laying concrete floors with a topping containing hard particles, such as carborundum, so as to afford a good foothold, or by giving them a wood float finish.

Each floor drain, including blood drains, should be equipped with a deep-seal trap (P-U or S-shaped are acceptable; Bell type traps are not acceptable). The drainage lines should be at least 4 inches in diameter and properly vented to the outside air. Drainage lines from toilet bowls and urinals shall not be connected with other drainage lines within the building unless positively trapped to prevent backing up and shall not discharge into a grease catch basin. Such lines shall be located so that if leakage develops it will not affect the product. Where there is likelihood that the water seals in traps will evaporate without replenishment from floor drainage, as in the case of dry-storage rooms, the floor drains should be provided with suitable removable plugs.

L. Sewage Disposal.

Sewage may be discharged into a municipal sewer system and if this is permitted by local ordinance it is most desirable. If the discharge is into a stream, the flow of water in the stream should be sufficient at all seasons of the year to carry the sewage well away from the plant. It is recommended that the system be checked by local health authorities having jurisdiction over such matters to determine if it is acceptable.

A letter from the proper health authority (state, county, city) indicating that the proposed sewage system is acceptable should be submitted to the Washington office before requesting a final survey of the plant prior to inauguration of inspection.

M. Water Supply.

The water supply must be ample, potable (safe for drinking) suitable for food processing, and distributed throughout the plant

under adequate pressure and in quantities sufficient for all operating needs.

Based on experience of the Inspection Service and on estimates furnished by processing plants about 30 gallons of water are needed to process a turkey and 5 gallons for a fryer.

Non-potable water is permitted only in those parts of the official plant where no product is handled or prepared, and then only for limited purposes such as on condensers not connected with the potable water supply, in vapor lines serving inedible products rendering tanks, and in sewer lines for moving heavy solids in the sewage.

It is necessary that we have on record a copy of satisfactory water report before inspection may be inaugurated. This may be obtained from the State Department of Health or some other agency authorized by the State Department of Health to issue the report. Forms to be used in supplying the Inspection Branch with this report are provided to all firms requesting inspection service. (See Exhibit No. 2).

N. Ventilation.

Ample ventilation shall be provided. It may be furnished by means of ventilating windows or by the use of intake fans, exhaust fans, forced air duct systems, or a combination of the above methods. The fresh air intakes should be so located that the air is not contaminated with dust, smoke, etc. If this is not possible, filtered air should be provided. Ventilation should prevent the condensation of moisture and its dripping into the edible products. The movement of air should be from the edible products rooms towards the poultry dressing and live poultry area.

O. Doors.

Doors to food processing rooms and refuse , rooms shall be equipped with self-closing devices. Doors to restrooms shall be self-closing if they open directly into food processing rooms.

P. Poultry Conveyors.

Overhead conveyor lines shall be raised in areas where traffic moves in and out to a height sufficient to prevent pushing of the raw product to one side. For an efficient operation the overhead lines should have as few turns as possible.

Q. Restroom Facilities.

The toilet facilities should be separate from the cloak room. Ample space should be provided. We do not specify lockers, but shelves and clothes racks are to be provided. Partitions and doors should be furnished for each toilet. Toilet facilities should be

arranged so that they will be conveniently located to the processing rooms. The toilet rooms should be ventilated to the outside of the building with the aid of an exhaust fan.

R. Lunch or Coffee Room.

If there are to be vending machines, coffee breaks, etc., and for accommodation of employees, we recommend a lunch or coffee room.

S. Inspector's Office.

The inspector's facilities are explained in the regulations but we recommend that they be located near the eviscerating operation in order that he may be close to the operation for observation. Private toilet and lavatory facilities are recommended but not required.

T. Ice Machines or Crushers.

Ice machines or crushers should be so located that the ice can be handled in a sanitary manner in the packing area. To save time and labor, the ice should drop directly into a wheeled tank which can be easily moved. Block ice shall be washed before it is crushed. Keep in mind that you are cooling a ready-to-cook product, and it is necessary that ice be handled in a sanitary manner.

U. Lavatories.

Lavatories should be conveniently located in processing rooms for the use of employees and inspectors. Each lavatory shall be supplied with hot and cold running water, liquid soap in a suitable dispenser, an ample supply of sanitary towels, and a suitable receptacle for used towels. Lavatories serving processing areas shall be other than hand operated. Ordinarily, one to three lavatories should be sufficient in each food processing room.

V. Equipment and Utensils.

Equipment shall be so constructed that it can be cleaned readily. Rust-resisting metal, such as stainless steel, should be used for equipment and utensils subject to hard usage and corrosion. Other metals, such as galvanized metal and aluminum are acceptable but they are difficult to clean and not too practical to use over a long period of time. Cutting boards should be constructed of hard maple or other suitable material such as plastic.

Water-wasting equipment, such as washers, cooling tanks and cooking vats, should be installed so that waste water is delivered into the drainage system without flowing over the floor. Chilling and cooking vats should be provided with overflow pipes at least two inches in diameter. The upper end of each overflow pipe shall be equipped with an open-end clean-out tee to facilitate cleaning.



Stationary equipment and equipment not readily movable should be placed at least 30 inches from walls, posts, and other fixed parts of the building and from other equipment to facilitate ready cleaning of outer surfaces. Vent stacks from covered cooking vats and open vats shall be so arranged as will preclude drainage of condensate back into the vats.

A separate washroom or area should be provided for cleaning hand trucks, utensils, and containers such as pans and trays. The room or area shall have adequate light and ventilation and an impervious, well-drained floor, and impervious walls and ceiling.

#### W. Blueprints.

We recommend the following method for showing information and specifications on blueprints. All information (Section 81.14 (b) 1 through 11) to be shown on the floor plan, such as equipment, ventilation, floor drains, self-closing doors, hot and cold water outlets, etc., should be drawn or printed in its proper location on the blueprint.

Please show specifications (Section 81.14 (c) 1 through 13) on the print as follows:

#### EXAMPLE OF SPECIFICATIONS

Room	Walls	Floor	Type Ceiling	Finish of Ceiling	Height of Ceiling
Dressing Room	Cement Plaster	Concrete	Open to Roof	Galvanized Metal	Varies 10-18 ft.
Eviscerating Room	Glazed Tile	"	Closed	Cement Plaster	11 ft.
Packing Room	"	"	"	"	"
Refuse Room	Cement Plaster	"	"	"	"
Cooler	"	"	"	"	9 ft.
Freezer	"	"	"	"	"
Men's Restroom	Painted Plywood	"	"	Painted Plywood	"
Women's Restroom	Cement Plaster	Tile	"	Cement Plaster	"
Etc.					
Etc.					

Screens. All windows opened for ventilation are screened.

Drainage. Adequate 1/4" per foot to drain. All drains trapped and vented to conform to city and state regulations. Floor drain openings 4" in diameter. Main drainage line 8" in diameter, laterals 4" in diameter. House drainage lines and toilet soil lines separate to a point outside the building. (If not separate, they must be trapped to positively prevent backing up, and so indicated on print.)

Heating. Steam, hot air, etc.

Water Supply. Public water supply. Gallons available per minute 150. No non-potable water in plant.

Hot Water Facilities. Boiler, mixing valves. Fifteen H.P. boiler.

Number of Men and Women Employees to Use Each Toilet Room. Fourteen women and 12 men.

Sewage Disposal. City sewer system, etc.

Approximate Hourly Rate of Production. Fowl 900, fryers 1100, turkeys 600 - 1000, etc.

The sheets of paper on which drawings or blueprints are made shall not exceed a size of 34" x 44". The drawings other than of the plot plan shall be made to a scale of 1/8" per foot, except that additional plans for some areas showing detail may be drawn to a scale of 1/4" per foot. The plot plan may be drawn to a scale of not less than 1/32" per foot. The drawings shall indicate the scale used and shall also indicate the floor shown (i.e., basement, first, or second).

Space for Approval Stamp. A contrasting space (white) of at least 2 1/2" x 4" is necessary on each sheet of blueprint for the placement of the formal mark of approval.

For further information, please direct your questions to:  
"Facilities Section, Inspection Branch, Poultry Division,  
Agricultural Marketing Service, United States Department of  
Agriculture, Washington 25, D. C."

SECTION III. SAMPLE FORMS AND EXHIBITS.

Exhibit No. 1

Form PY-500  
(1-15-58)

UNITED STATES DEPARTMENT OF AGRICULTURE  
Agricultural Marketing Service

APPLICATION FOR INSPECTION UNDER POULTRY PRODUCTS INSPECTION ACT

Application is hereby made for poultry inspection, in accordance with the applicable provisions of the regulations governing the inspection of poultry and poultry products (7 CFR Part 81) at the following-designated plant:

Name of Plant Poultry Plant, Inc.

Street Address 415 Jasper Road

City and State Rockland, Maine

Type of poultry processing operations Eviscerating - Canning

In making this application the applicant agrees to comply with the terms and conditions of the aforesaid regulations (including but not being limited to such instructions governing inspection of products as may be issued, from time to time, by the Administrator).

Poultry Plant, Inc.  
(Applicant)  
By /s/ John A. Smith  
(Signature)  
Title President  
415 Jasper Road  
(Street)  
Rockland Maine  
(City) (State)  
January 15, 1958  
(Date)

Application Granted:

Agricultural Marketing Service

By \_\_\_\_\_

Title \_\_\_\_\_

Date \_\_\_\_\_

Agriculture - Washington



Form PY-118  
(10-1-56)

Philadelphia Pa.  
(City) (State)

January 15, 1958  
(Date)

## CERTIFICATION OF WATER POTABILITY

Poultry Division  
Agricultural Marketing Service  
U. S. Department of Agriculture

Gentlemen:

We certify that the water supply of \_\_\_\_\_

Poultry Processors Inc.  
(Name of Company)

located at 925 Main St. Jonesboro Pa. has passed  
(Street & No.) (City) (State)

the tests prescribed by Pennsylvania Department of Health  
(Name of State Health Agency)

for safe drinking water, and water suitable for food processing.

/s/ William Smith  
(Signature)

William A. Smith  
(Name of Certifying Officer)

Director  
(Title)

Jones Smith Laboratory  
(Name of Certifying Agency)

NOTE: - Three completed signed copies of this form are to be returned to the  
above address.



